

Date: Friday, 9/1/2006 12:06:57 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.250 SUPPORT
Job Number : 28388
Estimate Number : 11057
P.O. Number : *N/A* Part Number : D28911
This Issue : 9/1/2006 S.O. No. *N/A* Drawing Number : D2891 REV A1
Prsht Rev. : NC Project Number : N/A
First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : A1
Previous Run : 28077 Material : *N/A*
Due Date : 9/30/2006 Qty: 10 Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est. C 02.11.26 Added P/O KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1954**C 06/09/05**(10)*

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

3.25 x 3.80

2.0 D6104003 17-4 SS Roundbar 3.25"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Support 2.25 dia

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

PBOC/09/13

4.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

*Issue P.O. 2068**C 06/09/18 (10)*

Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

turn per DSK076

5.0 QCT INSPECT ALL DIM TO DIM SHEET

*Review + inspect for*

Comment: INSPECT ALL DIM TO DIM SHEET

*transit damage 06/10/04 (10)**56 Inspect Level 5**Er 06/10/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/18/13/

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:06:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 28388

Part Number: D28911

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

Ep 06/10/16 x

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/10/16 x

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 06/10/16

9.0

POWDER COATING

POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

yl 06/10/30 x

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

yl 06/10/30 x 10 201

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57166

P 06/10/31 20 mg

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/10/31

Job Completion



C Loc 110131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28388
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.274	2.279		2.279	2.279	2.279	2.279		
B	3.702	3.722		3.711	3.710	3.707	3.711		
C	2.564	2.584		2.572	2.574	2.578	2.572		
D	0.718	0.738		0.719	0.713	0.718	0.716		
E	0.090	0.110		0.093	0.104	0.092	0.095		
F	2.464	2.484		2.474	2.473	2.474	2.470		
G	2.029	2.049		2.038	2.043	2.038	2.037		
H	2.964	2.984		2.973	2.974	2.972	2.972		
I	0.913	0.933		0.928	0.930	0.930	0.923		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.090	0.110		0.098	0.095	0.094	0.095		
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.189	0.189	0.189	0.189		
AB	0.240	0.260		0.250	0.247	0.247	0.246		
AC	0.115	0.150		0.122	0.122	0.124	0.123		
AD	0.040	0.060		0.044	0.049	0.045	0.048		
AE	0.010	0.020		0.015	0.015	0.015	0.015		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.290	0.310		0.308	0.303	0.306	0.297		
AH	0.115	0.150		0.138	0.136	0.137	0.136		
AI	0.454	0.474		0.460	0.460	0.460	0.460		
AJ	2.779	2.789		2.780	2.780	2.780	2.781		
AK	0.240	0.260		0.250	0.250	0.250	0.250		
AL	1.002	1.042		1.042	1.047	1.042	1.046		
AM	0.053	0.073		0.063	0.063	0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
AO	1.663	1.683		1.678	1.676	1.677	1.671		
AP	0.053	0.073		0.063	0.063	0.063	0.063		
AQ	0.022	0.042		0.032	0.032	0.032	0.032		
AR									
AS									
Accept/Reject									

Measured by: En	Audited by: JL
Date: 06/10/15	Date: 06/10/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF #	#

DART AEROSPACE LTD		Work Order: 28388
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	8	By	Date
Lathe Section									
A	2.274	2.279		2.279	2.279	2.279	2.279		
B	3.702	3.722		3.713	3.714	3.712	3.711		
C	2.564	2.584		2.543	2.574	2.574	2.571		
D	0.718	0.738		0.729	0.729	0.728	0.726		
E	0.090	0.110		0.091	0.098	0.100	0.100		
F	2.464	2.484		2.471	2.474	2.471	2.473		
G	2.029	2.049		2.031	2.036	2.031	2.033		
H	2.964	2.984		2.973	2.974	2.974	2.973		
I	0.913	0.933		0.921	0.928	0.925	0.922		
J	0.022	0.042		0.032	0.032	0.037	0.032		
K	0.090	0.110		0.095	0.095	0.100	0.095		
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.190	0.190	0.190	0.190		
AB	0.240	0.260		0.251	0.246	0.246	0.248		
AC	0.115	0.150		0.127	0.125	0.121	0.123		
AD	0.040	0.060		0.051	0.051	0.050	0.049		
AE	0.010	0.020		0.015	0.015	0.015	0.015		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.290	0.310		0.299	0.301	0.301	0.303		
AH	0.115	0.150		0.136	0.137	0.135	0.137		
AI	0.454	0.474		0.461	0.460	0.460	0.459		
AJ	2.779	2.789		2.780	2.782	2.781	2.780		
AK	0.240	0.260		0.252	0.250	0.250	0.250		
AL	1.002	1.042		1.040	1.042	1.040	1.040		
AM	0.053	0.073		0.063	0.063	0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
AO	1.663	1.683		1.677	1.680	1.674	1.677		
AP	0.053	0.073		0.063	0.063	0.063	0.063		
AQ	0.022	0.042		0.032	0.032	0.032	0.032		
AR									
AS									
Accept/Reject									

Measured by: <i>ED</i>
Date: 06/10/15

Audited by: <i>SL</i>
Date: 06/10/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>RF</i>	<i>RF</i>

DART AEROSPACE LTD		Work Order: 28388
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1/19	2/16	3/10	4/11		
Lathe Section									
A	2.274	2.279		2.275	2.275				
B	3.702	3.722		3.711	3.712				
C	2.564	2.584		2.574	2.576				
D	0.718	0.738		0.722	0.727				
E	0.090	0.110		0.094	0.099				
F	2.464	2.484		2.483	2.484				
G	2.029	2.049		2.031	2.036				
H	2.964	2.984		2.974	2.976				
I	0.913	0.933		0.928	0.928				
J	0.022	0.042		0.032	0.032				
K	0.090	0.110		0.095	0.097				
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.190	0.191				
AB	0.240	0.260		0.247	0.253				
AC	0.115	0.150		0.121	0.121				
AD	0.040	0.060		0.047	0.055				
AE	0.010	0.020		0.015	0.015				
AF	0.240	0.260		0.250	0.250				
AG	0.290	0.310		0.299	0.306				
AH	0.115	0.150		0.138	0.137				
AI	0.454	0.474		0.458	0.455				
AJ	2.779	2.789		2.780	2.780				
AK	0.240	0.260		0.250	0.250				
AL	1.002	1.042		1.040	1.041				
AM	0.053	0.073		0.063	0.063				
AN	0.257	0.262	DT8683	0.260	0.260				
AO	1.663	1.683		1.677	1.675				
AP	0.053	0.073		0.063	0.063				
AQ	0.022	0.042		0.032	0.032				
AR									
AS									
Accept/Reject									

Measured by: EP
Date: 06/10/16

Audited by: JL
Date: 06/10/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3

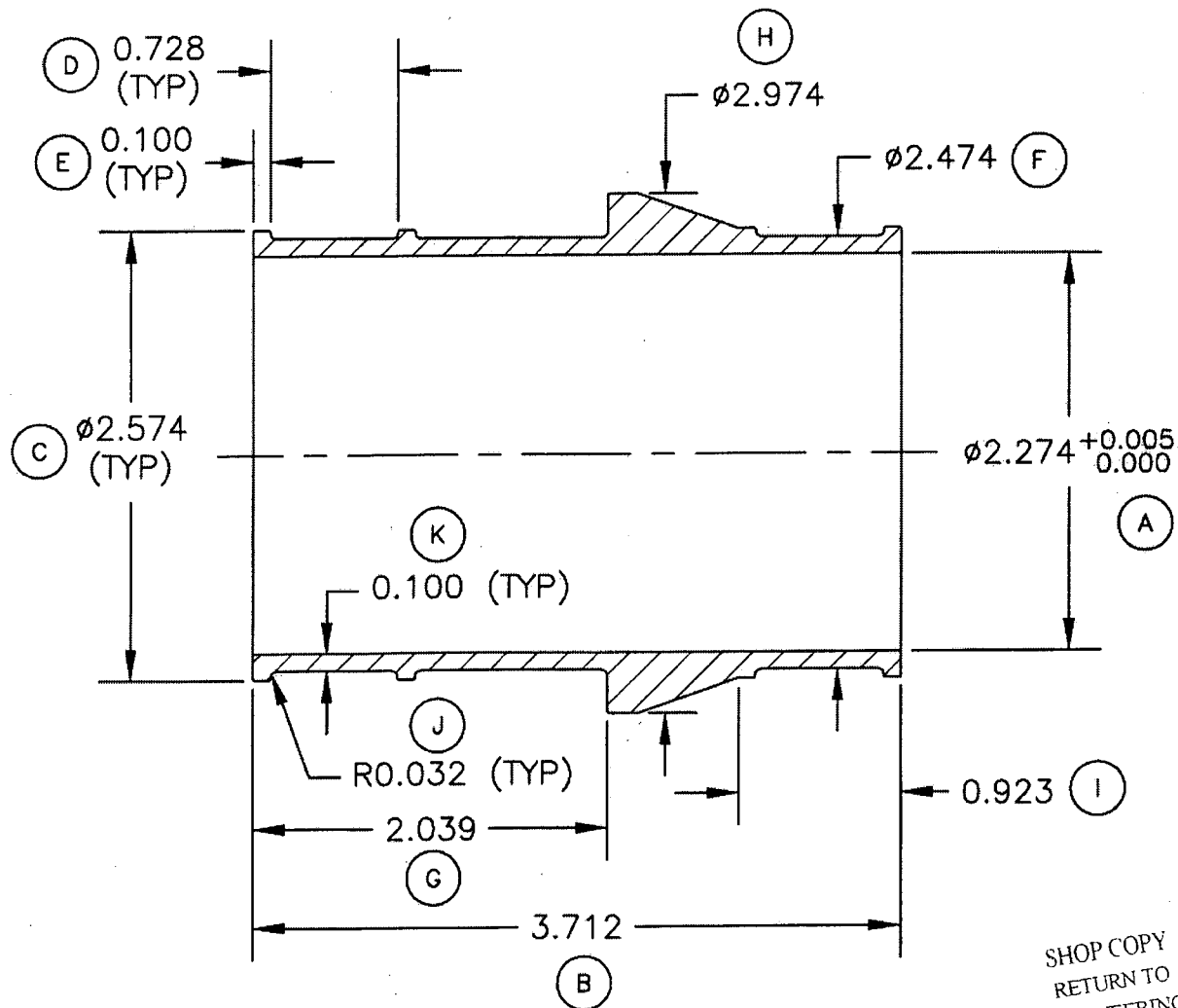


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AI	<i>CP</i> 02.01.23	UPDATE DIMS AS MANUFACTURED.	
A	00.11.17	NEW ISSUE	
DESIGN	<i>CP</i>	DART	DART AEROSPACE LTD. HARRISBURT, CHICAGO, CANADA
CHECKED	<i>CP</i>	DRAWING NO. D2891	REV. A SHEET 1 OF 1
DATE	00.11.17	TITLE Ø2.250 SUPPORT	SCALE 1:1

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01**D2891-1 TURNING DETAIL**

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**VENUS****VENUS WIRE INDUSTRIES LIMITED**

REGD.OFFICE : 19 Raghunath Mill Compound, S. B. Marg, Lower Parel, Mumbai- 400 013. (INDIA)

Tel.: 91-22-24978840 Fax : 91-24978846 E-mail : Sales@Venuswires.com Website : WWW.Venuswires.com

ISO: 9001:2000

REGISTERED FIRM

INSPECTION /MILL/QUALITY CERTIFICATE

No. BB/VW/2006-2007/0765

PRODUCT INFORMATION	CUSTOMER	: M/S. AMS SPECIALTY INC.								GRADE				: AISI-630			
	INVOICE NO.	: PM/042/EXP/2006-2007								HEAT NO.				: VBMU-0622			
	PRODUCT FORM	: STAINLESS STEEL BRIGHT BARS															
	DIMENSION	: 3 1/4"S.A.								Tol :- +/- 0.003"				QUANTITY		: 2050.30 LBS	
	IDENTIFICATION	: AJ 2546															
CONDITION : ANNEALED, PEELED CENT. GROUND & POLISHED																	
CHEMICAL COMPOSITION	ELEMENTS	C%	Si%	Mn%	P%	S%	Cr%	Ni%	Cu%	Mo%	N%	Nb%	Nb+TA				
	SPECIFIED	MIN MAX	----- 0.07	----- 1.00	----- 1.00	----- 0.040	----- 0.030	15.00 17.50	3.00 5.00	3.00 5.00	----- -----	----- -----	----- -----	0.15 0.45			
	RESULTS		0.032	0.370	0.680	0.033	0.022	15.500	4.300	3.200	0.050	0.024	0.290	0.2904			
MECHANICAL PROPERTIES			UTS		YS		R.A. %		ELONGATION %		HARDNESS						
	RESULTS		138.19 KSI		122.87 KSI		31.75		11.17		306 BHN						
HEAT TREATMENT: 1900°F SOLUTION ANNEALED RAPID COOLED.																	
REMARKS : <ul style="list-style-type: none">* CONTACT PROBE THERMOCOUPLES USED TO DETERMINE CHARGE TEMPRATURE.* MATERIAL IS FREE FROM MERCURY AND RADIUM CONTAMINATION.* NO WELDING PERFORMED.* DISC MACROETCHED AND NO PIPE OR CRACK OBSERVED.* MATERIAL PRODUCED WITHOUT OZONE DEPLETING SUBSTANCES.* MICROSTRUCTURE : 2.08% FERRITE.* MELTING PRACTICE EAF CONVERTOR TO VOD.* MATERIAL CONFORMS TO ASTM A564/A564-02A TYPE 630, CONDITION A, ASTM A370-03A, ASTM E340, ASME SA564/SA564M, AMS 5643Q,* THIS CERTIFICATE IS ACCORDING TO EN 10204/3.1B* AMS ORDER NO : 4277* COPPER & BRASS ORDER NO. : CJ5743* COUNTRY OF ORIGIN : INDIA																	
We hereby certify that the material described herein has been manufactured and tested with satisfactory results in accordance with the customers requirements, needs and expectations. Mechanical test results is the one result taken randomly from the lot.												 (MANAGER Q.A.)					
DATE: 18/07/2006																	

DOC.No. F/QAD/06,R1

PLANT : ATKARGAON, TAKAI ADOSHI ROAD, KHALAPUR, KHOPOLI- 410203.
PHONES : 02192-262334/263404/262610 FAX : (02192) 2668873

For any information / query please quote Invoice No. & TC No. / Invoice No. & Bundle No.



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	DSK076	Support as per Dwg DSK076 D6104-003 B28388	2068
8	DSK076	Support as per Dwg DSK076 D6104-003 B28077	2068
10	DSK076	Support as per Dwg DSK076 D6104-003 B26715	2068
20	DSK077	Support as per Dwg DSK077 D6104-003 B28389	2068
8	DSK077	Support as per Dwg DSK077 D6104-003 B27970	2068
7	DSK077	Support as per Dwg DSK077 D6104-003 B28078	2068
14	DSK080	Support as per Dwg DSK080 D6104-011 B27266	2068

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, September 20, 2006

